

Date:
User:Friday, 17/08/2007 11:21:21 AM
Linda Lacelle

Process Sheet

Split into
85 07/10/16

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLOWER MOTOR ADAPTER
 Job Number : 34084-2
 Estimate Number : 12133
 P.O. Number : N/A
 This Issue : 17/08/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 32042
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-01-31 JLM
 est rev B added comment @ # 5.0 06.11.01 EC

Part Number : D3476043
 Drawing Number : D3476 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 11/09/2007 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34763 DOME



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Qty Part Number Description Batch

1 D3476-3 blower motor adapter B27025

mf

2.0 D34767 TUBE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number Description Batch

2 D3476-7 Tube B34105

mf

3.0 D34761 duct



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Qty Part Number Description Batch

1 D3476-1 Duct B34104 34396

mf

4.0 NAS1031C3W Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Qty Part Number Description Batch

4 NAS-1031C3W Nutplate M105728

mf

07-10-15

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot Weld Tubes And Nut plates as per Dwg D3476 and Dart QSI 018

mf

07-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/14	1	Split WO	SB	07/10/14	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/10/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 34084

Part Number: D3476043

Job Number



Seq. #:

Machine Or Operation:

Description :

***** D3476-1 goes on top of D3476-3 *****

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/10/16 (1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/16 (1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 07-10-16

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/17 (1)

Job Completion

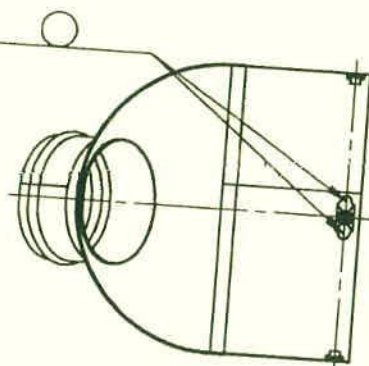


07-10-17

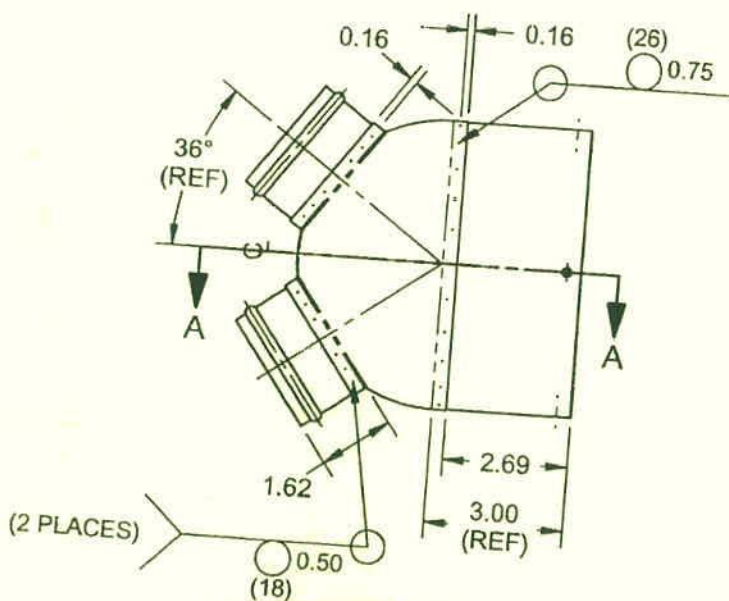


DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	RE SHEET 2 SC
CHECKED H	APPROVED H		
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	

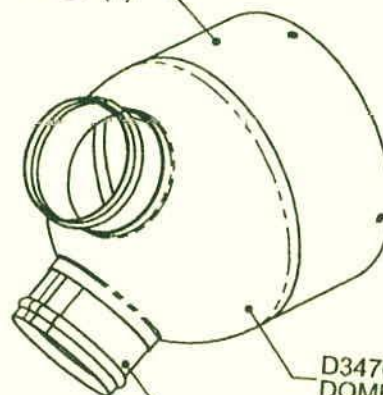
LOCATE AND
SPOT WELD
NUT PLATES
(4 PLACES)



SECTION A-A

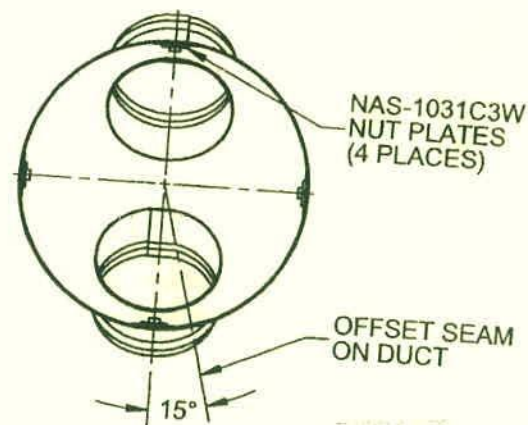


D3476-1
DUCT (1)



D3476-3
DOME (1)

D3476-7 TUBE
(2 PLACES)



NAS-1031C3W
NUT PLATES
(4 PLACES)

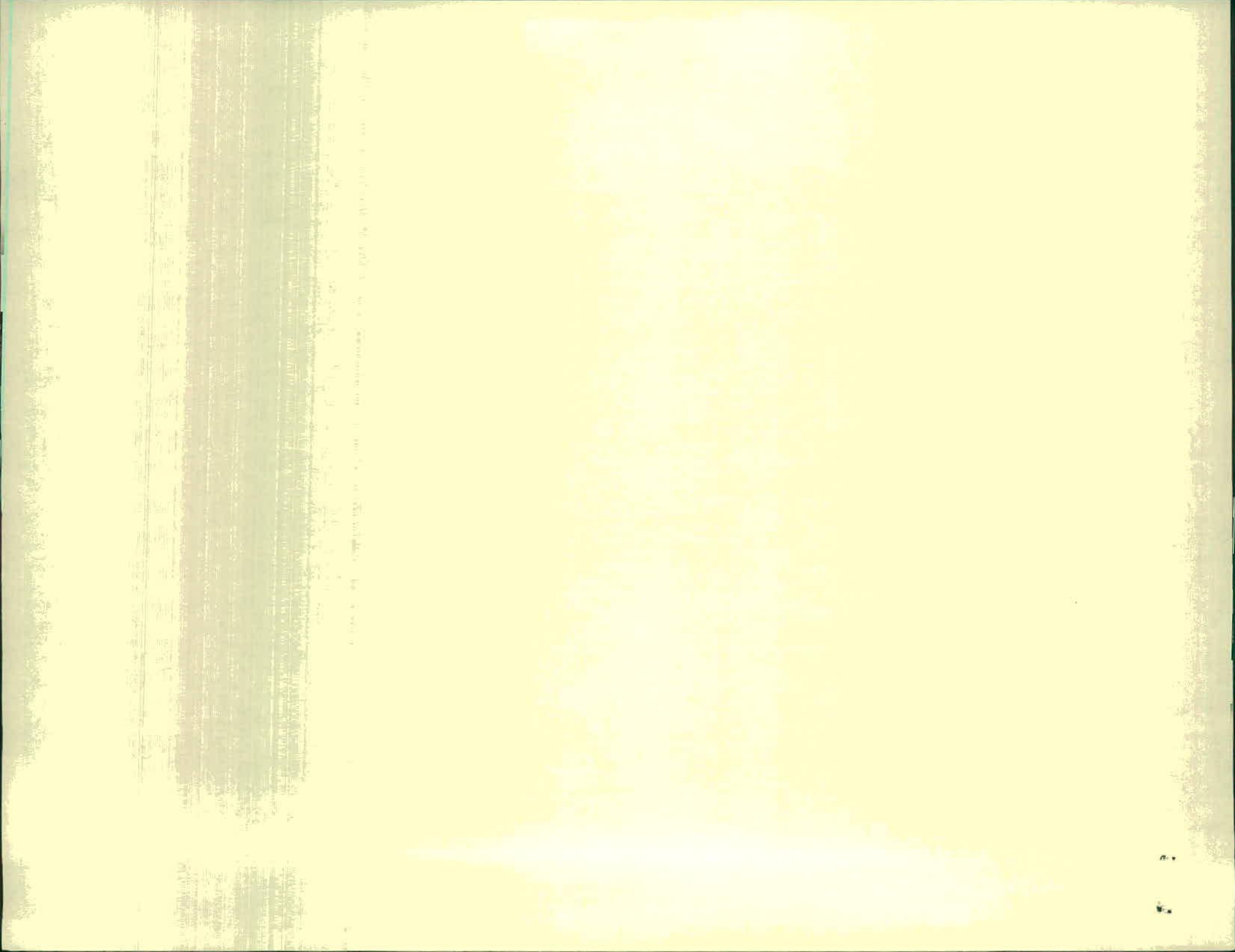
OFFSET SEAM
ON DUCT

D3476-043 BLOWER MOTOR ADAPTER WELDMENT

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE



SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 21

EMPLOYEE: Melanie Fautoux

PART NUMBER: D3476-043

JOB NUMBER: 34084

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	[<u>-</u>]	[]
PENETRATION:	[<u>-</u>]	[]
PULL STRENGTH:	[<u>-</u>]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/16/16
QUALIFIER: SJS

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